

1 What is claimed is:

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- 3 1. A method of making a smoking article wrapping material, comprising:
- 4 providing a smoking article wrapping material substrate wound on a first roll;
- 5 unwinding the substrate from the first roll;
- 6 applying in a pattern on the substrate a plurality of bands of a coating formulation,
- 7 wherein each of the plurality of bands comprises a first coating layer effective in reducing
- 8 an inherent porosity of the substrate, and a second coating layer different from the first coating
- 9 layer and overlying the first coating layer, and
- 10 wherein at least one of the coating layers in each band is applied by spraying.
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- 12 2. The method of claim 1, wherein the applying the plurality of bands in a pattern further
- 13 comprises applying each band transversely on the wrapping material, each band having a
- 14 longitudinal width and spaced apart along a longitudinal length of the wrapping material.
- 15
- 16 3. The method of claim 1, wherein the applying the plurality of bands further comprises
- 17 applying each coating layer in pre-determined amounts.
- 18
- 19 4. The method of claim 1, further comprising utilizing the wrapping material to make a smoking
- 20 article having reduced ignition propensity.
- 21
- 22 5. The method of claim 1, wherein the bands of first and second coating layers are applied to the
- 23 substrate online during making of a smoking article.
- 24
- 25 6. The method of claim 1, further comprising winding the wrapping material substrate onto a
- 26 second roll, wherein the bands of first and second coating layers are applied to the substrate
- 27 offline prior to making of a smoking article.
- 28
- 29 7. The method of claim 6, wherein the second coating layer is effective in preventing blocking
- 30 when the wrapping material is unwound from the second roll.
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- 1 8. The method of claim 1, further comprising curing the bands sufficiently to solidify the coating  
2 formulation on the substrate.  
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- 4 9. The method of claim 1, wherein the coating formulation further comprises a burn control  
5 agent.  
6
- 7 10. The method of claim 1, wherein the coating formulation further comprises a liquid form.  
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- 9 11. The method of claim 1, wherein the coating formulation is essentially free of solvent.  
10
- 11 12. The method of claim 1, wherein the coating formulation further comprises a solid powder  
12 form.  
13
- 14 13. A method of making a smoking article wrapping material, comprising:  
15 providing a smoking article wrapping material substrate wound on a first roll;  
16 unwinding the substrate from the first roll;  
17 applying in a pattern on the substrate a plurality of bands of a coating formulation,  
18 wherein each of the plurality of bands comprises a first coating layer effective in reducing  
19 an inherent porosity of the substrate, and a second coating layer different from the first coating  
20 layer and overlying the first coating layer, and  
21 wherein at least one of the coating layers in each band is applied by ink jet coating.  
22
- 23 14. The method of claim 13, wherein the applying the plurality of bands in a pattern further  
24 comprises applying each band transversely on the wrapping material, each band having a  
25 longitudinal width and spaced apart along a longitudinal length of the wrapping material.  
26
- 27 15. The method of claim 13, wherein the applying the plurality of bands further comprises  
28 applying each coating layer in pre-determined amounts.  
29
- 30 16. The method of claim 13, further comprising utilizing the wrapping material to make a  
31 smoking article having reduced ignition propensity.

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2 17. The method of claim 13, wherein the bands of first and second coating layers are applied to  
3 the substrate online during making of a smoking article.  
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5 18. The method of claim 13, further comprising winding the wrapping material substrate onto a  
6 second roll, wherein the bands of first and second coating layers are applied to the substrate  
7 offline prior to making of a smoking article.  
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9 19. The method of claim 18, wherein the second coating layer is effective in preventing blocking  
10 when the wrapping material is unwound from the second roll.  
11  
12 20. The method of claim 13, further comprising curing the bands sufficiently to solidify the  
13 coating formulation on the substrate.  
14  
15 21. The method of claim 13, wherein the coating formulation further comprises a burn control  
16 agent.  
17  
18 22. The method of claim 13, wherein the coating formulation further comprises a liquid form.  
19  
20 23. The method of claim 13 wherein the coating formulation is essentially free of solvent.  
21  
22 24. The method of claim 13, wherein the coating formulation further comprises a solid powder  
23 form.  
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